

Work Order ID 121007

121007

Page 1

June-16-14 1:15:59 PM

Item ID: D4646-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Plenum Cap Assembly

Start Date: 6/27/14 Start Qty: 20.00

Cust Item ID:

Required Date: 7/02/14 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 140617

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4646	A								

100 0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 24687
Purchase Part Number: PC7041-1
Supplier: BIRK AEROSYSTEM CORPORATION
Certificate of conformity is required

CL 14/06/19 96

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Memo

0.00

Packaging

14/11/29 (96)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 121007

121007

Page 2

June-16-14 1:15:59 PM

Item ID: D4646-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Plenum Cap Assembly
 Start Date: 6/27/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 7/02/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

mf 14-7-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

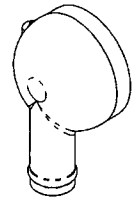
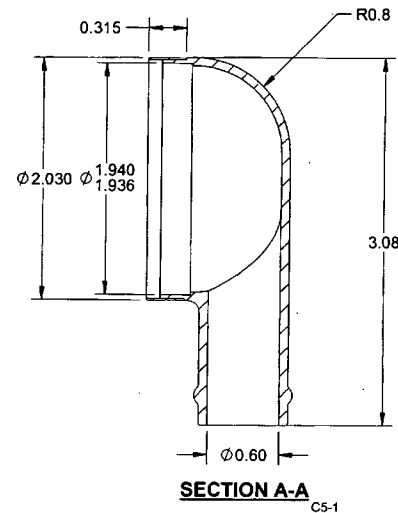
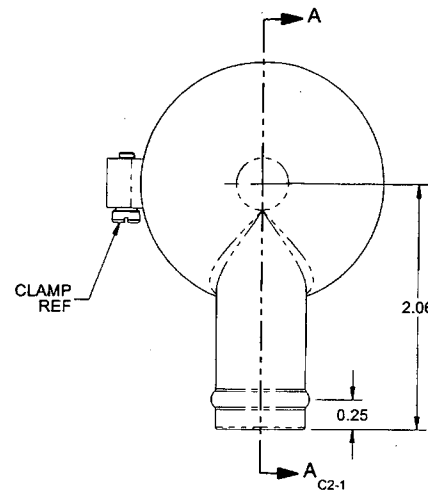
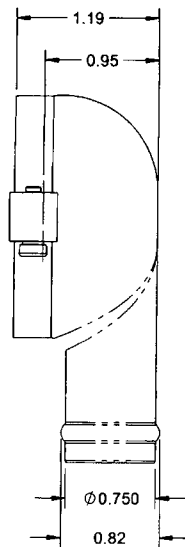
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SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 121007 MLS
1406-17

DART PART NUMBER	DESCRIPTION	VENDOR	VENDOR PART NUMBER	WEIGHT (lbs)
D4646-1	PLENUM CAP WITH GEAR CLAMP	BIRK AEROSPACE CORPORATION	PC7041-1	0.05

D4646-X PLENUM CAP ASSEMBLY

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: PER TABLE

REV.	DESCRIPTION	RF	DATE
A	NEW ISSUE		12.07.25
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	12.07.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4646** REV. A
SHEET 1 OF 1
TITLE **PLENUM CAP** SCALE NTS

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NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24687**

Purchase Order Date 6/19/2014

PO Print Date 6/19/2014

Page Number 1 of 2

Order From :

VU-BIR001

BIRK AEROSYSTEMS CORPORATION
14321 COMMERCIAL DRIVE
GARDEN GROVE, CALIFORNIA 92843

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone

714-554-9782

Ship To Contact

Ship To Phone

Ship Via:

FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	PC7041-1 AS PER DWG D4646 REV. A B121007	Plenum Cap Assembly	7/31/2014 Yes 7/31/2014		96.00 Each	\$6.98	\$670.08

Line Total: \$670.08

2	71401-45	PROCUREMENT QUALITY CLAUSES	7/31/2014 No 7/31/2014		1.00	\$0.00	\$0.00
PROCUREMENT QUALITY CLAUSES							
A005 RIGHT OF ENTRY							
A016 PERSONNEL QUALIFICATION							
A025 CERTIFICATE OF CONFORMANCE							
A040 NOTIFICATION OF QUALITY OF ESCAPE							
A041 QUALITY MANAGEMENT SYSTEM							
A042 DART NOTIFICATION BY SUPPLIER							
A043 RETENTION OF QUALITY DOCUMENT							

Line Total: \$0.00

Note:

6/19/2014

BAC**BIRK AEROSYSTEMS CORPORATION**

14321 Commerce Drive

Garden Grove, California 92843

Telephone: (714) 554-9782 Telefax: (714) 554-3659

DATE: 07/23/14

CUSTOMER PO: PO24687

SHIPPER NO.: DAR140723

CERTIFICATE OF CONFORMITY / PACKING LIST

SHIP TO: **DART AEROSPACE LTD**
1270 ABERDEEN
HAWKESBURY ON K6A 1K7
Canada

PO ITEM	PRODUCT NO.	DESCRIPTION	QUANTITY		LOT CODE	LOT QTY	SERIAL NO.
			ORDERED	SHIPPED			
1	PC7041-1	PLENUM CAP ASSY (REV. -)	96	96	1407620 MFG: 1430	96	-
		VALUE FOR CUSTOMS: \$670.08 USD Country of Manufacture: United States					

CLAIMS FOR SHORTAGES OR MATERIAL DISCREPANCY MUST BE MADE WITHIN 15 DAYS AFTER DATE SHIPPED.

CERTIFICATE OF CONFORMANCE: THIS IS TO CERTIFY THAT THE PARTS FURNISHED ON THIS ORDER HAVE BEEN FUNCTIONALLY TESTED IN ACCORDANCE WITH STANDARD PROCEDURES DEFINED BY BAC. MATERIAL AND/OR PARTS FURNISHED IN THIS ORDER HAVE BEEN MANUFACTURED IN ACCORDANCE WITH ALL APPLICABLE INSTRUCTIONS AND SPECIFICATIONS. PHYSICAL AND CHEMICAL DATA WHICH PERTAINS TO THIS ORDER ARE AVAILABLE FOR INSPECTION.

QTY VERF

**FEDEX PRIORITY COLLECT**

#6

**QUALITY CONTROL INSPECTOR**